

Work Order ID 163999

Tuesday, July 11, 2017 7:16:56 AM

163999

Page 1

Item ID: D3533-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Set Screw
 Start Date: 7/11/2017 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 7/14/2017 Req'd Qty: 50.00 ***50*** Customer:

Reference: **DAS 13 9-89**
 Approvals: Process Plan: **JUL 11 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3533	Rev B

100	PURCHASING	0.00				50	JUL 11 2017	DAS 13 9-89
100								
Purchasing	Memo	0.00						
Purchasing	Issue P/O: 36992 Purchase Part Number: 92311A564 Supplier: MAC							
	MASTER CARR Certificate of conformity is required							

110	Receive & Inspect for Damage & Mat'l Certs	0.00						
110								
Packaging	Memo	1.00						
Packaging	Ensure material certification is attached							

120	QC6- All purchased or subcontracted products	0.00						
120								
QC	Memo	0.00						
Quality Control								

50, SP17-7-13

50 JUL 14 DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 163999***163999***

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Tuesday, July 11, 2017 7:16:56 AM

Item ID: D3533-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Set Screw

Start Date: 7/11/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST033	0.00							
130									
Packaging	Memo	0.50							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	5.00							
Quality Control									

SD**JUL 17 2017****DAS
6****9-89****17/7/18****DAS
21
9-89****JUL 18 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, July 11, 2017 7:16:55 AM

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Work Order ID: 163999

163999

Parent Item: D3533-1

D3533-1

Parent Item Name: Set Screw

Start Date: 7/11/2017

Required Date: 7/14/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 06-07-25 JLM verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
92311A564		Purchased		No		110	Each	0.0000	1	50			
92311A564									**				
Set Screw													

50x SP17-7-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

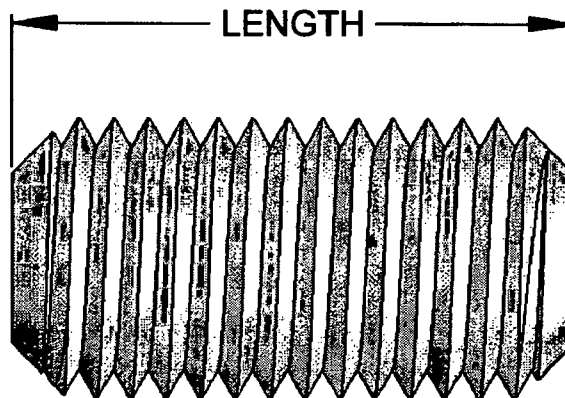
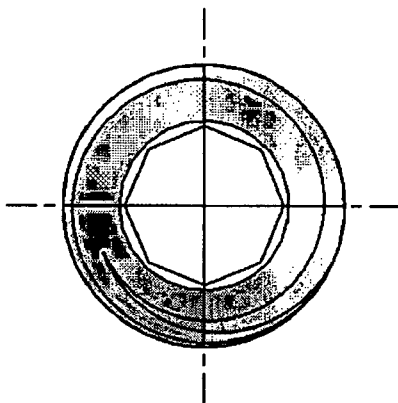
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3533	REV. B SHEET 1 OF 1
DATE 07.06.14		TITLE SET SCREW	SCALE NTS
REV	DATE	DESCRIPTION	
A	06.07.12	NEW ISSUE	
B	07.06.14	ADD D3533-3; ADD MATERIAL/FINISH COLUMN	

SPECIFICATION CONTROL DRAWING

RELEASED
07.08.03 H



B

PART NUMBER	MATERIAL AND FINISH	SIZE	LENGTH	POSSIBLE SUPPLIER
D3533-1	18-8 STAINLESS STEEL	1/4-28 UNF	1.000	McMASTER-CARR, P/N 92311A564
D3533-3	BLACK OXIDE ALLOY STEEL	#6-40 UNF	0.188	McMASTER-CARR, P/N 91375A161

B

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W10:163999

NOTES:

- 1) TYPE: CUP POINT HEX HEAD SET SCREWS
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36992

Purchase Order Date 7/11/2017

PO Print Date 7/11/2017

Page Number 1 of 4

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUL 11 2017

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	USD
Ship Via:	Purolator ground ppd	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	92311A599 AS PER DWG D2712 REV. B B164000	SET SCREW	7/13/2017 Yes 7/13/2017		200.00 Each	\$0.20	\$40.52
Line Total:							\$40.52
2	92311A564 AS PER DWG D3533 REV. B B163999	Set Screw	7/13/2017 Yes 7/13/2017		50.00 Each	\$0.23	\$11.65
Line Total:							\$11.65
3	59915K274 AS PER DWG D4777 REV. A B163998	Rod End Bearing	7/13/2017 Yes 7/13/2017		5.00 Each	\$19.05	\$95.25

Note:

7/11/2017

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO36992

Order Placed By
Chantal Lavoie

McMaster-Carr Number
5705260-01

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07/11/2017

Line	Product	Ordered	Shipped
1	92311A599 18-8 Stainless Steel Cup-Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50	4 Packs	4
2	92311A564 18-8 Stainless Steel Cup-Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50	1 Pack	1
3	59915K274 Corrosion-Resistant Ball Joint Rod End, 3/8"-24 Thread, Right Hand	5 Each	5
4	66775A41 5/32" Nosepiece for Air-Powered Tool for Blind Rivets	2 Each	2
5	66775A41 5/32" Nosepiece for Air-Powered Tool for Blind Rivets	4 Each	4
6	3842A23 Pick, Screwdriver Handle with Plain Grip, Straight Tip, 5.25" Long	2 Each	2
7	5338A42 Precision-Tip Pick, Straight Tip, 6" Overall Length, 0.025" Tip Diameter	2 Each	2
8	71455K64 Size AAA Alkaline Disposable Batteries, Packs of 24	1 Pack	1
9	7861T536 Round-Tip Detail Paint Brush with 5/64" Diameter x 5/16" Long Red Sable Bristle, Packs of 12	1 Pack	1

SP 17-7-13

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Notes about your shipment

The U.S. Department of Transportation regulates the shipping of line 8. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.